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D4749-1

Job Sheet 183221



Part No: D4749-1

Job Qty: 60 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/13/18

Job Tracking No:

Due Date: 9/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12.11.27 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea		9/28/18	0.00	0.00	Start Up Machining-3	VHS	JBO 18/10/18
100	Hardinge	60 pcs		9/28/18	0.00	6.82	Hardinge	V	" "
110	QC	60 pcs		9/28/18	0.00	0.00	QC8		KT 2018-10-25
130	Packaging	60 pcs		9/28/18	0.00	0.00	Packaging3-2	DAS 6	OCT 25 2018
140	QC21-SA	60 Ea		9/28/18	0.00	0.00	QC21	6	

Part Op
Descriptions: 100 - 1-TURN AS PER FOLIO FB & DWG

1-89

DAS
21

OCT 25 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-R0.375	17-4 SS Round Bar .375"	1.8600 ft (.031 ea)	90-Start up Operation	5121272

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-R0.375	2	2	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.194Inches + 0.002 - 0.005	0.196 0.189	Diameter	
2	Spacer	0.245Inches + 0.000 - 0.005	0.245 0.240	Diameter	
3	Spacer	0.160Inches ± 0.010	0.170 0.150		
4	Spacer	0.025Inches + 0.010 - 0.100	0.035 (0.075)		
5	Spacer	45.000Degrees ± 0.500	45.500 44.500	Angle	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No: _____ NCR No: _____ Date: _____ Serial No: _____ Job No: _____ Part: D4749-1 Job No: 183221 Serial No/Batch: S121272 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 10/25/18	DISPOSITION	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td style="width:33%;">Cross tube ☐</td> <td style="width:33%;">Water Jet ☐</td> <td style="width:33%;">Engineering ☐</td> </tr> <tr> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table> Disposition	Cross tube ☐	Water Jet ☐	Engineering ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Composite ☐	Supplier ☐	
Cross tube ☐	Water Jet ☐	Engineering ☐												
Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐												
Finishing ☐	Rec/Store/Packaging ☐	Other ☐												
Composite ☐	Supplier ☐													
		MRB (QSI042) Approval _____												
		Completed By _____												
		Lead hand / Supervisor Approval Verification _____												
		QC / QA Coordinator Approval _____												

Root Cause	Pressure/Forced	Temperature/Cure	Power Loss/Surge
Environment ☐	☐	☐	☐
Design ☐	Bending ☐	Set-up ☐	Folio/Program ☐
Doc/Data ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐
Equip/Tooling ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐
Handling/Pre ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐
Material ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐
Internal Transport ☐	Crushing ☐	Countersink ☐	Off-set ☐
Tribal Knowledge ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐
LOA ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐
Substation ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐
Past Expiry Date ☐			
Misidentified ☐			

Root Cause	Pressure/Forced	Temperature/Cure	Power Loss/Surge
No Re-verification ☐	☐	☐	☐
Operator ☐	Bending ☐	Set-up ☐	Positioned Wrong ☐
Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Outside Dimensions ☐
Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Over/Under tolerance ☐
Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Part Incorrect ☐
Use for Testing ☐	Cuffs ☐	Contamination ☐	Part Lost/Missing ☐
Poor Information ☐	Crushing ☐	Countersink ☐	Part Moved ☐
Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Drawing ☐
Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Finish ☐
Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misread ☐
Manufacturing Process ☐			Turning Sequence ☐
Past Due ☐			

OTHER : _____